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PLATE-GLASS MAKING.

Methods of Manufacture Employed in the

American Factories.

There are in the United States five

plate glass manufacturing and another

is soon to be established at Findlay,

Ohio. The manufacture of plate glass

is usually of very large size.

In the center is the square

melting furnace, with openings on two

parallel sides for working purposes,

while along two sides of the great

building are arranged annealing

ovens, which are sometimes thirty by

twenty feet in order to receive the

immense plates that are to be annealed.

Two kinds of pots are used, the ordi-

nary one opens on the top, for melting

the glass, and cisterns or cures, in

which the molten glass is carried to the

casting table. In France the cistern

is usually of a quadrangular form,

with a groove in each of its sides, or as

in the case of the larger cisterns, in

two parallel sides, in which the tongs

or iron-frames are fitted when the

cistern is moved. Between each two

parts in the furnace are placed, ac-

cording to their size, one or

more cures. In some establishments

the cistern is not used, the metal

being poured from the pot in which it

is melted on to the casting table. Six-

teen hours is usually allowed for the

melting, and the same time for the

metal to remain in the cistern; but

the latter time is often extended in

order that the air-bubbles may

escape and the excess of soda become

volatilized. Toward the last the tem-

perature is allowed to fall, and the

glass then acquires the slight degree

of viscosity suitable for casting. The

molten glass is transferred from the

pot into the adjacent cures by means

of means of wrought iron ladles with

long handles. When the glass is in a

proper condition to be cast, the

tongs are raised, consisting of two

powerful bars of iron united like two

scissors blades, and resting upon two

wheels, is pushed into the opening

made in the furnace, and the cistern

is clamped in the quadrant formed

at the extremity of the tongs, two work-

men manipulating the handles at the

other extremity. The cistern thus

taken from the furnace, while filled

with molten glass, is placed on an

other carriage and quickly conveyed

to the casting table. This consists of

a massive slab, usually of cast iron,

supported by a frame, and generally

placed at the mouth of the annealing

oven. On each side of the table are

ribs or bars of metal, which keep the

glass from proper position, and by the

height determine the thickness of the

plate. A copper or bronze cylinder

about a foot in diameter, resting upon

these bars, extends across the table.

After being heated by hot coals placed

upon it, the table is carefully cleaned,

preparatory to casting. The cistern

containing the molten glass is raised

from the furnace, and is placed on a

carriage, its outside carefully cleaned,

and the glass skimmed with a

copper ladle. The cistern is

now swung round over the table, over

which a roller covered with cloth is

drawn to remove all impurities, and

the molten glass poured out in front of

the cylinder, which being pulled from

one extremity of the table to the other,

spreads out the glass in a sheet of

uniform breadth and thickness. While

the plate is still red hot, about two

inches of its end is turned up like a

flange, against which an iron rake-like

instrument is placed, and the plate is

thrust forward into the furnace, where

the temperature of which is that of

dull redness. Another plate is

now immediately cast upon the hot

table, and the annealing oven, when

filled, is closed and left for about five

days to cool. The process for smooth-

ing the glass, is rubbing the surface to

be smoothed, with another surface

cloth of coarse or fine, and at the same

time applying sand and emery of differ-

ent degrees of fineness, and water

between the two impinging surfaces.—

Tribune Herald.

FULL OF FUN.

—Cook books are evidently not of

modern origin, for Bacon says: "Some

books are to be tasted, some eaten, and

some digested."

—An Irishman writing to a debtor,

says: "I confidently expected before

this to receive from you an agreeable

"surprise."—*Shoe and Leather Reporter.*

—Scene—Doctor's house. Little boy

at the front door—"Is the doctor in?"

"Cause, if he is, I want to see him at

once." Servant—"He's not in." Lit-

tle boy—"Well, just as soon as he gets

home, you tell him to come over to our

house and take that baby away he left

last week. It's in the way."—*N. Y.*

Ledger.

—Kate comes upon Henry, who is

playing upon a flute. Kate—"Why

Henry, you do that quite well; I should

think you would take lessons." Hen-

ry, who has been taking lessons for the

last ten years, does not feel flattered,

but makes no sign as he replies: "I

have thought of it."—*Chicago Ad-*

vance.

—"Well," said Razorpen, more

kindly than was his custom, "I can

tell you how you can improve the play

a little." "How?" asked Inkwell,

gratefully. "You see you kill the vil-

lain in the last act?" "Well," said

that is good. Now, make him kill all

the other characters in the first."—

Burdette.

—One of Many—"Little Dot—"Diek,

your mamma said if you'd be good and

stayed in the yard she'd bring you

some candy when she comes home."

Little Dick—"I know; but she won't."

She always forgets about it." "Well,

she said if you went out she'd give you

a spanking. Now, you'd better stay

in." "No; she always forgets that

too."—*Omaha World.*

—A Virginia colored girl, who has

not been long in New York, was given

some lessons by her mistress a few

evenings ago. She sat it slowly and

with a resist, but refused to eat any

supper. Surprised at her loss of ap-

petite, the mistress received the fol-

lowing explanation: "Golly, missus,

couldn't put no supper 'board dat

puddin'." "There are three things," said

Brumstone to his wife, "that a woman

can't be persuaded to do without."

"She can't, eh?" said Mrs. B., in an

incredulous tone. "I guess she can do

without them as well as man can, if

not better. What are they?" "Food,

clothes and life," quietly replied

Brumstone; and his wife retorted: "You

think you're smart, don't you?"—

Drake's Traveller's Magazine.

—A Scotchman was riding a donkey

one day across a sheep pasture, but

when the animal came to the sheep

drain he would not go over. So the

man rode back a short distance,

turned, and applied the whip, thinking,

of course, that the donkey, when going

at the top of his speed, would jump

the drain. But when the donkey got to

the drain he stopped sharply, and the

man went over his head. No sooner had

he touched the ground than he got up,

and, looking his best straight in the

face, said: "Veera weel pitched; but,

then, how are ye going to get over yer-

self?"—*N. Y. Ledger.*

